

Date: Tuesday, 12/5/2006 8:15:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET	
Job Number	: 29775		Part Number	: D23623	
Estimate Number	: 10260		Drawing Number	: D2362 REV E1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/5/2006 S.O. No. : N/A		Drawing Revision	: E1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/5/2007	
Previous Run	: 29436		Qty:	15 Um: Each	
Written By	: <i>[Signature]</i>		Comment	: Est: G 0045.18 Added inspection level 8 EC	
Checked & Approved By	: <i>[Signature]</i>				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2265	Step Support Casting	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)	
		Step Support	
		Pick:	
		Qty Part Number Description Batch	
		1 D2265 Step Support <i>B29079</i>	<i>En 06/12/28</i>
2.0	HAAS1	HAAS CNC-VERTICAL MACHINING #1	
		Comment: Machine per folio D2362-3	<i>En 06/12/28 x 15</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: Inspect Level 2	<i>En 06/12/28 x 15</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>En 06/12/28</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	<i>SAC 07/01/07 15</i>
		Deburr	
6.0	POWDER COATING	POWDER COATING	
		<i>M102391</i>	
		<i>MS</i>	
		<i>RE/40</i>	
		<i>07/01/09</i>	<i>(15)</i>
		<i>07/01/09</i>	<i>(15)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:15:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 29775

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/01/10

8.0 D23971 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number Description Batch

1 D2397-1 Rubber B27768 (x4) B29809 (x11)

ml

9.0 D23973 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number Description Batch

1 D2397-3 Rubber B27769 (x4) B29810 (x11)

ml

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D23623

Batch M 102565

ml 07/01/10

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/01/10 (S)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1169

07/01/11 (S) 07/01/11 15

13.0 QC21 FINAL INSPECTION/W/O RELEASE



15

Comment: FINAL INSPECTION/W/O RELEASE

07/01/11

Job Completion



07/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29775
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1

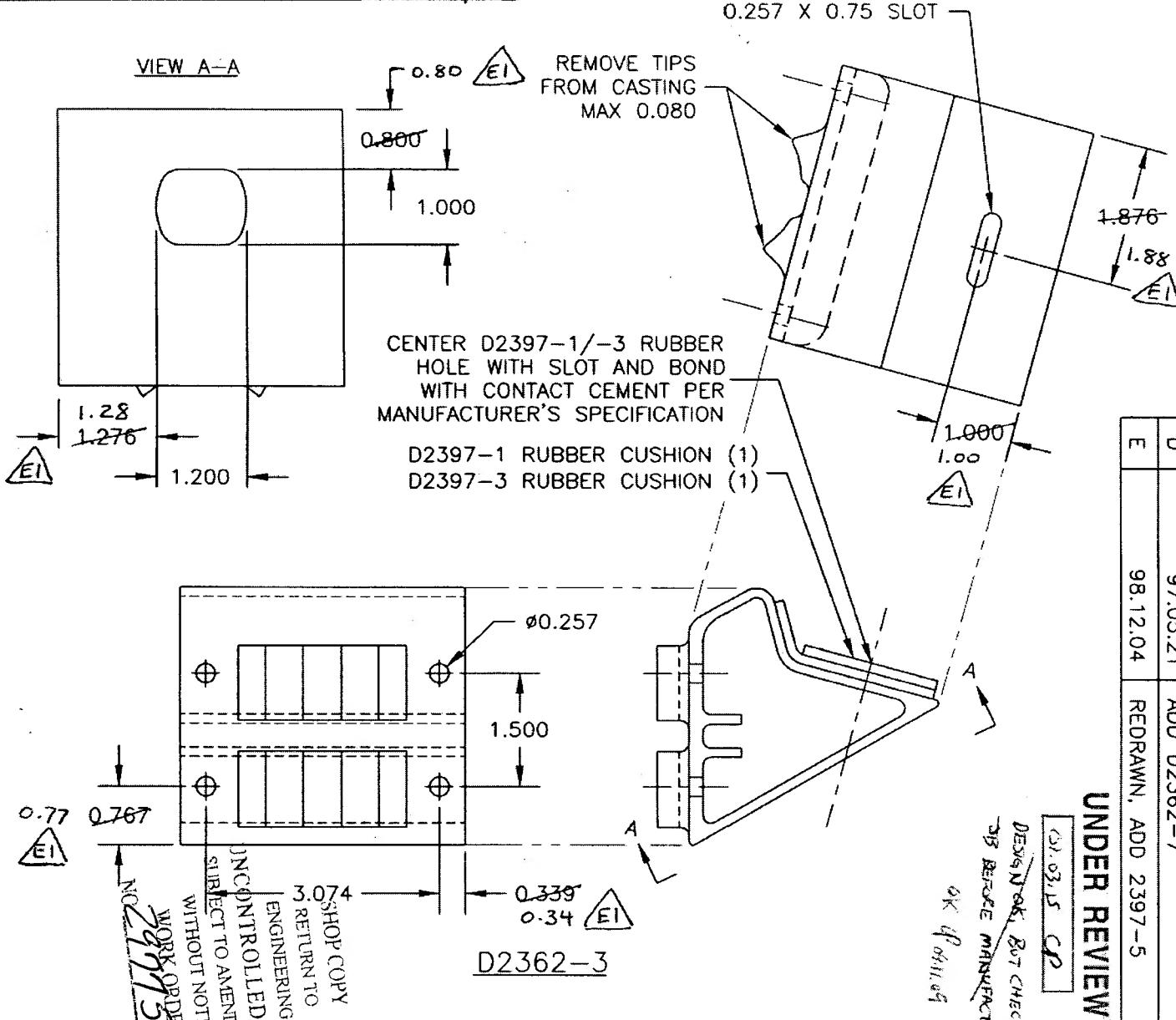
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>EJ</u>	Audited by:	<u>anf</u>	Prototype Approval:	N/A
Date:	<u>06/12/28</u>	Date:	<u>06/12/28</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF <i>✓</i>	<i>✓</i>

EL 03.10.07 TOLERANCE CHANGE ~~RF~~



RELEASED
98.12.14 KE



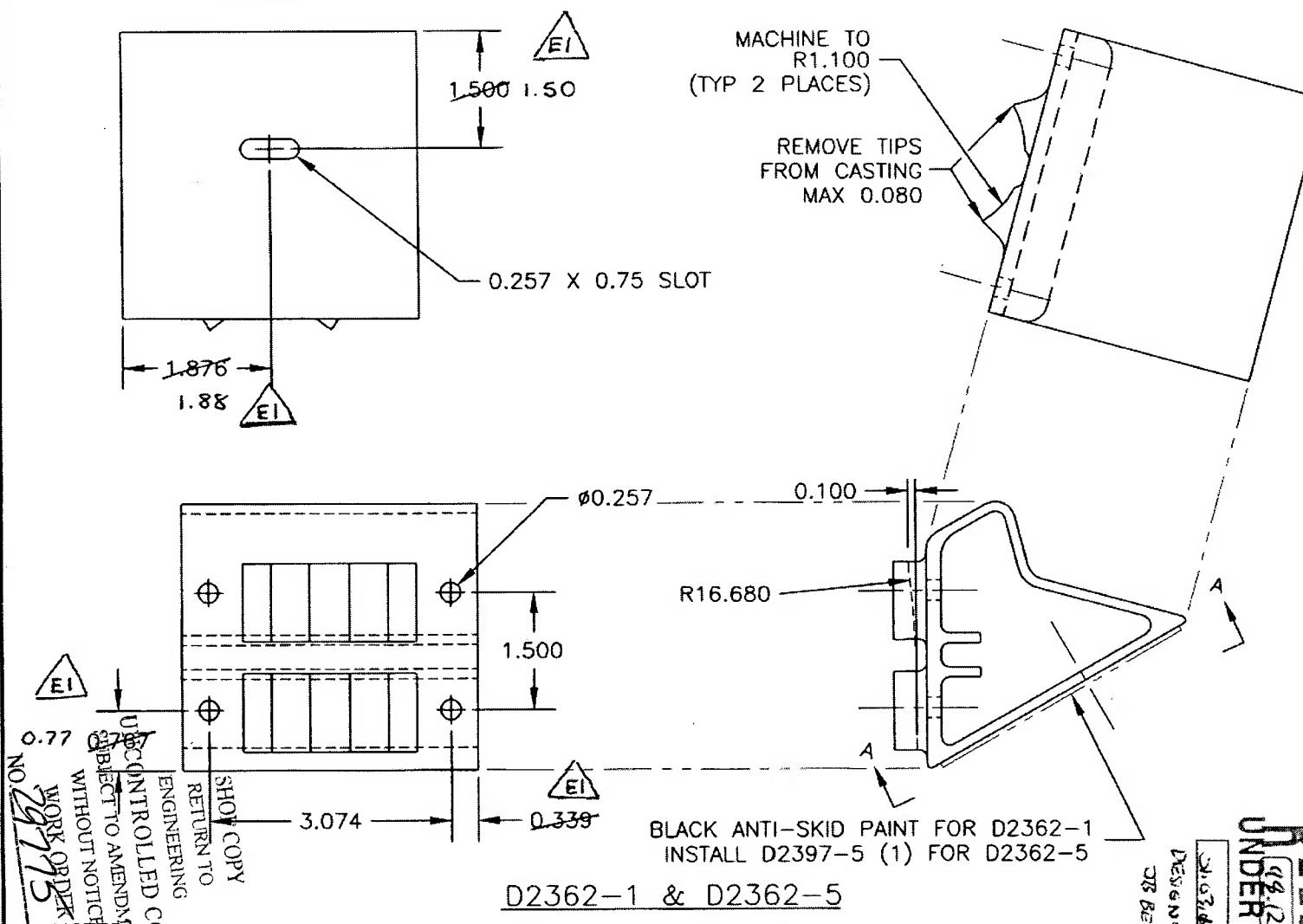
DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW
(03.03.15 CP)

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE

OK
03.11.09

VIEW A-A



DART

© DART 1995

DESIGN DW	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>MF</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SHEET 2 OF 3 SCALE 1:2

**RELEASED
UNDER REVIEW**

34345 CP
DESIGNOK, BUT CHECK W/
D2397-5
BEFORE MANUFACTURE
OK
P. 10/10

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PLANT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

~~TOLERANCES~~ TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.7

WELD PER DART
QSI 004

Technical drawing of a rectangular part with a grid pattern. The part is 3.074 units wide and 1.500 units high. The top edge has a thickness of 0.767. The drawing includes a note 'SHOP COPY' and a dimension of 0.339 for the bottom edge. A feature with a diameter of $\phi 0.257$ is located at the top right. The drawing also shows a dashed line representing a hidden feature.

3.750 (REF)

DESIGN OR, BUT
TRY BEFORE

~~DESIGN OR, BUT CHECK WITH
JS3 BEFORE MANUFACTURE~~

11

31.83.15 CP

DRAWN BY C. J. B.	APPROVED H. H.	DRAFTS	
		DRAFTS	
DRAWING NO. D2362		SHEET 3 OF 3	
TITLE STEP SUPPORT BRACKET		SCALE 1:2	
DATE 98.12.04	REV. E	HAWKESBURY, ONTARIO, CANADA	
CHECKED H. E.	DATE	BART AEROSPACE LTD	

ENCL.
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
15